

Work Order ID 54729 - 2

split

December 17, 2009 11:34:31 AM



Page 1

Item ID: D3929-041 *AD1*

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00 *3*

Cust Item ID:

Req'd Date: 23/12/2009 Req'd Qty: 6.00 *3*

Customer:

Reference:

Approvals: Process Plan: *RP*

Date: *0412-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3929	Rev A
-------	-------

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3929

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

IB 10-1-4

⑨

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

IB 10-1-4

Work Order ID 54729

December 17, 2009 11:34:31 AM



Page 2

Item ID: D3929-041

Revision ID:

Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00

Required Date: 23/12/2009 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Memo

Set Up/
Run Hours

0.00

0.00

278 10/01/04

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

(79) /

130



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

PD 10.01.05

140



Large Fab

Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

316L rod batch: ~~M109213~~

M109213

0.00

0.00

Ph ->

~~PD 10.01.05~~ (6)

PD 10.01.08. (3)

W/O: 54729		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/01/08/40		W/O was split due to extras made. 6 parts in segment (split-1) and 3 parts on this w/o. (split-2)				h		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item ID 54729

17, 2009 11:34:32 AM

Accept

Setup Start

Stop

Item ID: D3929-041

Revision ID:

Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00

Required Date: 23/12/2009 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 10/01/12 ~~*10/01/05*~~

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 5 10/01/12

(13)

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10/01/12

3x SH 10/01/14

Basket call

Work Order ID 54729

December 17, 2009 11:34:32 AM



Page 4

Item ID: D3929-041

Revision ID:

Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00

Required Date: 23/12/2009 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/14 *JA*

MF
10-1-13

Picklist Print

December 17, 2009 11:34:36 AM

Page 1

Work Order ID: 54729

Parent Item: D3929-041

Parent Item Name: Gusset Assembly

Comments:

Start Date: 17/12/2009

Required Date: 23/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	SF	107.0791	2.8421	4.3		



304/316 0.125 Sheet

HB 10-1-4

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

107.0791

112663

107.0791

130

Each

57.0000

12.0000

112663

D3907-1

Manufactured

No



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

17

53673

17

Main Warehouse

WA

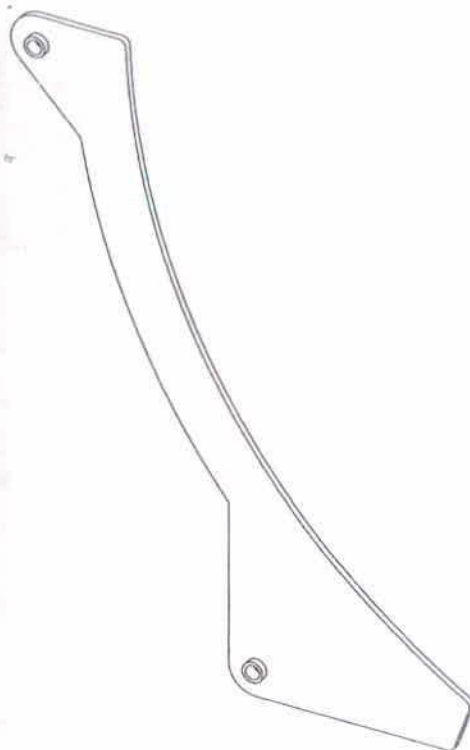
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54042

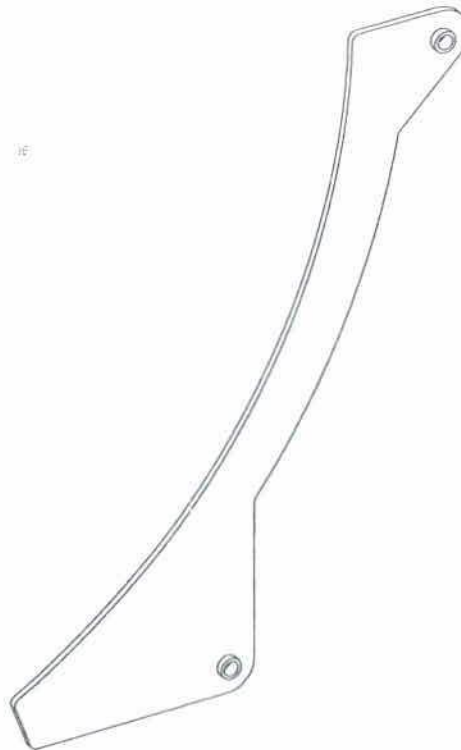
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PD 10.01.05

6 PD 10.01.08



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54729

09-12-17

RELEASED
09/04/2 MB

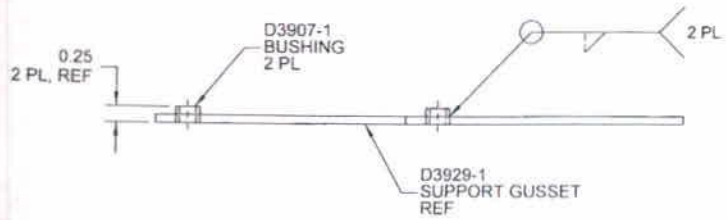
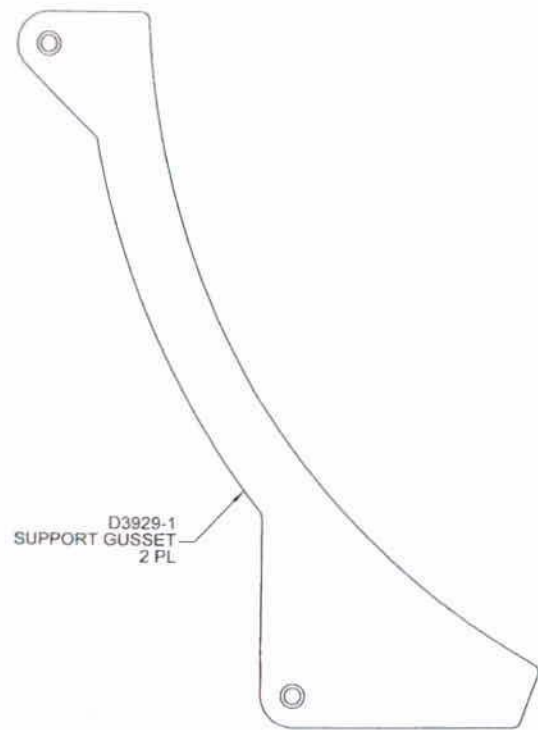
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

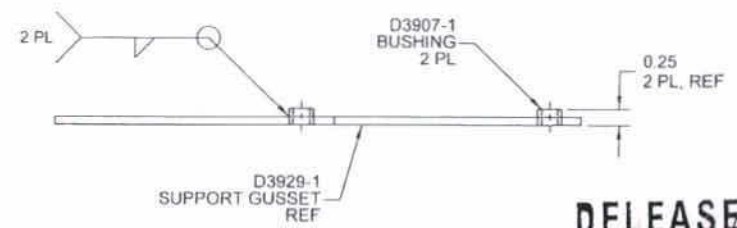
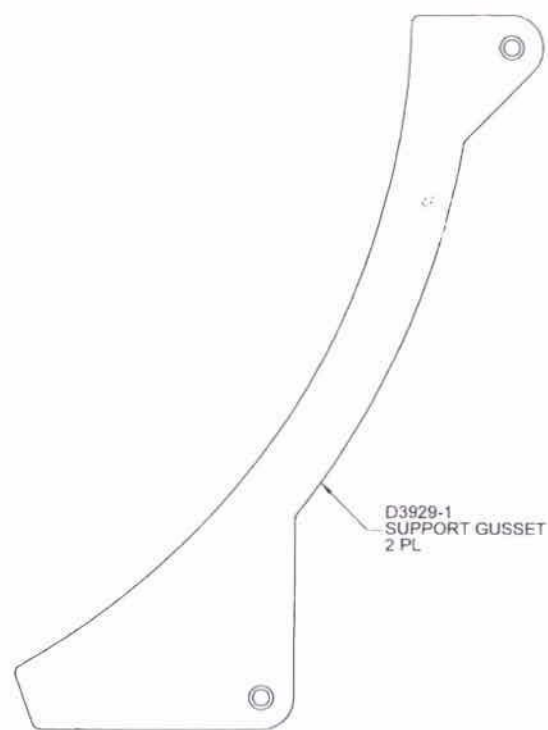
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A
SHEET 1 OF 3
TITLE **GUSSET ASSEMBLY** SCALE NTS

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D3929-041 GUSSET ASSEMBLY

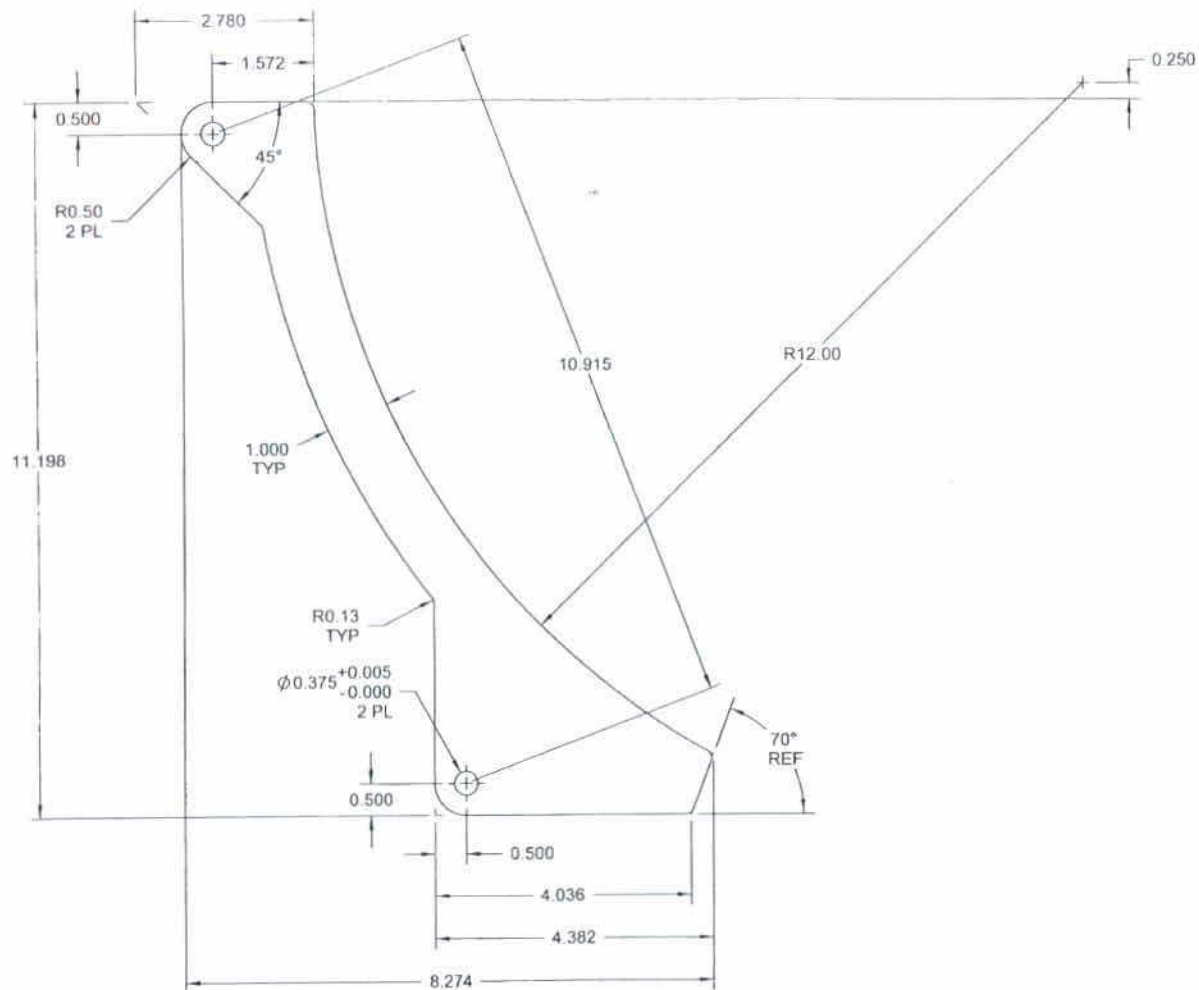


D3929-042 GUSSET ASSEMBLY

RELEASED
29/04/22 ND

W10 54729

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CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE GUSSET ASSEMBLY	SCALE
DE APPR.		NTS	
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D3929-1 SUPPORT GUSSET

RELEASED
09/04/22 JWD

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN		DRAWING NO.	REV. A
DRAWN		D3929	SHEET 3 OF 3
CHECKED		TITLE	SCALE
MFG. APPR.		GUSSET ASSEMBLY	NTS
APPROVED		DATE	09.04.03
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs